

Work Order ID 141113

Wednesday, January 27, 2016 8:33:08 AM

141113

Page 1

Item ID: DSI 9464-011

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube Tuning

Start Date: 1/27/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/3/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: ML5

Date: **JAN 27 2016**

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3955

A

DSI 9464

B

DAS
6
9-89

DAS
28
9-89

JAN 29 2016

100 Document Control

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP DSI 9464-011
CHG001

JAN 27 2016

DAS DAS
6 27
9-89 9-89

110 Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

DAS
28
9-89

JAN 29 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY					
Environment ☐		No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐		Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐		Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐		Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐		Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐		Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐		Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐		Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐		Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐		Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐		Manufacturing Process ☐	OTHER : ☐					
Misidentified ☐		Past Due ☐						

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Item ID: DSI 9464-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube Tuning

Start Date: 1/27/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/3/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS
28
9-89

JAN 29 2016

130

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP DSI 9464-011
Location : FG122DAS
28
9-89

JAN 29 2016

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ JAN 29 2016

MLJ JAN 29 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : ☐									

Picklist Print

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Page 2

Work Order ID: 141113

141113

Parent Item: DSI 9464-011

DSI 9464-011

Parent Item Name: Skidtube Tuning

Start Date: 1/27/2016

Required Date: 2/3/2016

Start Qty: 1.00

Required Qty: 1.00

D3955-21 Manufactured No

110 Each 6.0000 2 2

DAS
6
9-89

D3955-21

Gasket

DAS
28
9-89

Location

Loc Qty

Loc Code

ST064

6

134121

6

2

D3955-23 Manufactured No

110 Each 6.0000 2 2

DAS
6
9-89

D3955-23

Template

DAS
28
9-89

Location

Loc Qty

Loc Code

ST064

6

134122

6

2

CR3212-4-04 Purchased No

110 Each 302.0000 38 38

DAS
6
9-89

CR3212-4-04

Cherry Rivet

DAS
28
9-89

Location

Loc Qty

Loc Code

CCK005

100

m133077

100

LG001

96

m126534

96

ST320

106

m132317

106

38

AN3-5A Purchased No

110 Each 218.0000 4 4

DAS
6
9-89

AN3-5A

Bolt

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

24

m133686

24

ST350

194

m133686

74

m134055

120

4

DAS
6
9-89
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Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 141113

141113

Parent Item: DSI 9464-011

DSI 9464-011

Parent Item Name: Skidtube Tuning

Start Date: 1/27/2016

Required Date: 2/3/2016

Start Qty: 1.00

Required Qty: 1.00

AN3-6A

Purchased

No

110

Each

398.0000

4

4

AN3-6A

Bolt

DAS 27
6 9-89

Location

Loc Qty

Loc Code

over003

300

M133932

125

M134055

175

ST306

1

M131305

1

ST349

97

M133561

97

DAS
28
9-89

AN3-7A

Purchased

No

110

Each

229.0000

4

4

AN3-7A

Bolt

DAS 27
6 9-89

Location

Loc Qty

Loc Code

over003

150

M129507

50

m133694

100

ST349

79

m132763

46

m132803

33

DAS
28
9-89

AN3-10A

Purchased

No

110

Each

254.0000

4

4

AN3-10A

Bolt

DAS 27
6 9-89

Location

Loc Qty

Loc Code

GA

33

m132763

33

over003

200

m133992

200

ST349

21

m133694

21

DAS
28
9-89

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Shop Packet Print

Page 3

Picklist Print

Wednesday, January 27, 2016 8:33:12 AM

Page 4

Work Order ID: 141113

141113

Parent Item: DSI 9464-011

DSI 9464-011

Parent Item Name: Skidtube Tuning

Start Date: 1/27/2016

Required Date: 2/3/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0332J

Purchased

No

110

Each

1,611.000

6

6

NAS1149D0332.J

Washer

DAS

6

9-89

27

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

CA	14	
m129682	14	
FP001	60	
m129682	60	
GA	265	
m132677	265	
ST260a	600	
m133988	600	
ST264	672	
m133498	672	

MS21042L3

Purchased

No

110

Each

2,597.000

2

2

MS21042L3

Nut

DAS

6

9-89

27

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

CCK007	2000	
m134039	2000	
FP001	163	
m133790	163	
GA	195	
m133790	195	
ST304	239	
m133790	239	

JAN 27 2016

REFERENCE ONLY

DAS
28
9-89

Part List

Qty -011	Part Number	Description	Weight
X	DSI 9464-011	SKIDTUBE TUNING KIT	N/A
2	D3955-041	DOUBLER ASSEMBLY	0.25 lb/ 0.11 kg
2	D3955-3	COVER PLATE	0.64 lb/ 0.29 kg
2	D3955-5	0.063" THICK PLATE	0.64 lb/ 0.29 kg
6	D3955-7	0.125" THICK PLATE	1.28 lb/ 0.58 kg
2	D3955-21	GASKET	0.08 lb/ 0.04 kg
2	D3955-23	TEMPLATE	N/A
38	CR3212-4-04	RIVET	N/A
4	AN3-5A	BOLT	N/A
4	AN3-6A	BOLT	N/A
4	AN3-7A	BOLT	N/A
4	AN3-10A	BOLT	N/A
6	NAS1149D0332J	WASHER	N/A
2	MS21042L3	NUT (OR MS21042-3)	N/A

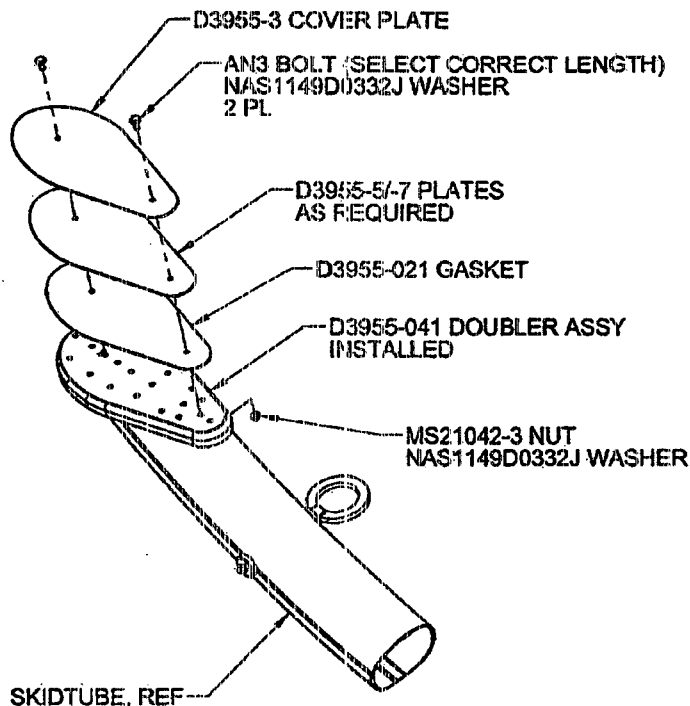


Figure 2

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-Q-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.04.14
CERT. NO.: SH96-88
ISSUE NO.: 3

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	DSI 9464	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SKIDTUBE TUNING KIT	NTS
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